



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

001021

D350-567-141
Job Sheet 172333



Part No: D350-567-141

Job Qty: 1 ea

Part Name: Floor Window Close Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/15/18

Job Tracking No:

Due Date: 2/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B 12.01.23 AS PER ECN12-511 DD
VERF:EC IPP REV:C 12.03.05 AS PER ECN12-537 DD VERF:EC IPP REV:D 13.04.01 AS PER DSI9590
REV:E DD VERF:JLM IPP REV:E AS PER DSI9590 REV F JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/23/18	0.00	0.00	Start Up Stores/Pkg-2		FEB 20 2018
110	Packaging	1 pcs		2/23/18	0.00	0.00	Packaging1-3		FEB 20 2018
120	QC	1 pcs		2/23/18	0.00	0.00	QC4		
125	DC	1 pcs		2/23/18	0.00	0.00	DC		
130	Packaging	1 pcs		2/23/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		2/23/18	0.00	0.00	QC21		FEB 21 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A	Bolt	7 Ea (7 ea)	90-Start up Operation	
AN525-10R6	Screw	2 Ea (2 ea)	90-Start up Operation	
AN525-832R7	Screw	2 Ea (2 ea)	90-Start up Operation	
D3802-1-024"	Window Seal (\$ Per Foot)	2 Ea (2 ea)	90-Start up Operation	
D4434-041	Fwd Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	
D4434-047	Cover Assembly	1 Ea (1 ea)	90-Start up Operation	
D4435-045	T/R Bellcrank Cover Assembly	1 Ea (1 ea)	90-Start up Operation	
D4435-9	Bracket	2 Ea (2 ea)	90-Start up Operation	
D4436-041	Aft Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	
D4441-1	Rubber Seal	2 Ea (2 ea)	90-Start up Operation	
MS21042L06	Nut	7 Ea (7 ea)	90-Start up Operation	
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	
MS21042L3	Nut	5 Ea (5 ea)	90-Start up Operation	
MS21059L3	Nut Plate	2 Ea (2 ea)	90-Start up Operation	
MS35206-229	Screw	7 Ea (7 ea)	90-Start up Operation	
NAS1149F0332P	Washer	12 Ea (12 ea)	90-Start up Operation	
NAS1149FN616P	Washer	14 Ea (14 ea)	90-Start up Operation	
NAS1149FN816P	Washer	2 Ea (2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-3A	7	272	0
	AN525-10R6	2	284	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																	
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval																															
Description Work Order Deviation			Disposition																																
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 832-5200 Email: sales@dartero.com www.dartaerospace.com DART AEROSPACE Container No: S043702 Part: D350-567-141 Job No: 172333 Serial No/Batch: S043702 Revision: DSI 9590 Inspector: Date: 02/20/18					Completed By																														
					Lead hand / Supervisor Approval Verification																														
					QC / QA Coordinator Approval																														
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td style="width:50%;">Environment ☐</td><td style="width:50%;">No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>			Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	CAUSE CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; vertical-align: top;"> ☐ Pressure/Fr ☐ Bending ☐ Centre Not ☐ Cracks ☐ Crimp/Kink ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter </td> <td style="width:33%; vertical-align: top;"> ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes </td> <td style="width:33%; vertical-align: top;"> ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center </td> </tr> <tr> <td style="vertical-align: top;"> ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence </td> <td colspan="2"></td> </tr> </table>			☐ Pressure/Fr ☐ Bending ☐ Centre Not ☐ Cracks ☐ Crimp/Kink ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence		
Environment ☐	No Re-verification ☐																																		
Design ☐	Operator ☐																																		
Doc/Data ☐	Offset/Setup ☐																																		
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Handling/Pre ☐	Training ☐																																		
Material ☐	Use for Testing ☐																																		
Internal Transport ☐	Poor Information ☐																																		
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OTHER : _____																																			

AN525-832R7	2	76	0
D3802-1	2	194	0
D4434-041	1	3	0
D4434-047	1	3	0
D4435-045	1	5	0
D4435-9	2	9	0
D4436-041	1	3	0
D4441-1	2	159	0
MS21042L06	7	185	0
MS21042L08	2	854	0
MS21042L3	5	3,582	0
MS21059L3	2	201	0
MS35206-229	7	74	0
NAS1149F0332P	12	3,730	0
NAS1149FN616P	14	149	0
NAS1149FN816P	2	256	0

Part Specifications

Specifications could not be found.

Plex 2/15/18 12:45 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



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Tel (613) 632-5200

Master Unit 001021

Containers on Master Unit 001021				
Serial No	Part No	Customer Part No	Status	Quantity
S043697	AN3-3A	AN3-3A	Allocated	7
S043696	AN525-10R6		Allocated	2
S043695	AN525-832R7		Allocated	2
S043675	D3802-1		Allocated	2
S043693	D4434-041		Allocated	1
S043692	D4434-047		Allocated	1
S043687	D4435-045		Allocated	1
S043679	D4435-9		Allocated	2
S043678	D4436-041		Allocated	1
S043676	D4441-1		Allocated	2
S043665	MS21042L06	MS21042L06	Allocated	7
S043664	MS21042L08		Allocated	2
S043662	MS21042L3	MS21042L3	Allocated	5
S043659	MS21059L3	MS21059L3	Allocated	2
S043658	MS35206-229		Allocated	7
S043656	NAS1149F0332P		Allocated	12
S043650	NAS1149FN616P		Allocated	14
S043648	NAS1149FN816P		Allocated	2

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
		1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
Note that the structural reinforcement around the window opening is still required.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable.
D350-567-115 - OK to remove D3295-041
D350-567-031 - OK to remove D3212-1
D350-567-011 - OK to remove D2214
D350-567-021 - OK to remove D2951
3) It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT NTS	
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Change Record

PAGE 1 OF 1

Part Number: D350-567-141

Description: FLOOR WINDOW CLOSEOUT

[illegible]